

5/10

DART AEROSPACE LTD	Work Order:	2224
Description: Saddle billet	Part Number:	D6101-003
Drawing: D6101 Rev. A	Qty:	50

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	HA	05.01.17	50
2	PURCHASING	Issue P/O: <u>79074/23</u> a) Description: Alluminum billet b) 7.875" x 6.250" x 2.00" thick c) Tolerance on all dimensions are +0.030"/-0.000" d) Grain direction along 7.875" length e) Material: 7075-T7351 (QQ-A-250/12) Material certification required	UL	05.01.18	50
3	RECEIVING	Receive & Inspect for transit damage Ensure certification are attached	CL	05/01/26	50
4	QC	Inspect level 6 Check certification to Dwg D6101 for compliance	Er	05/02/07	50
5	STORES	Identify & stock	CL	05/02/07	50
6	EXPEDITING	Close W/O Cost / part <u>59.09</u> <u>50</u> <u>05/02/09</u> <u>Inspect</u> <u>50</u> <u>level 21</u> <u>56.22</u>	HA	05.02.10	50

RF
03.06.05

Rev	Date	Change	Revised By	Approved
A	01.05.04	New Issue	EC	EC

RELEASED

EC 01.05.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

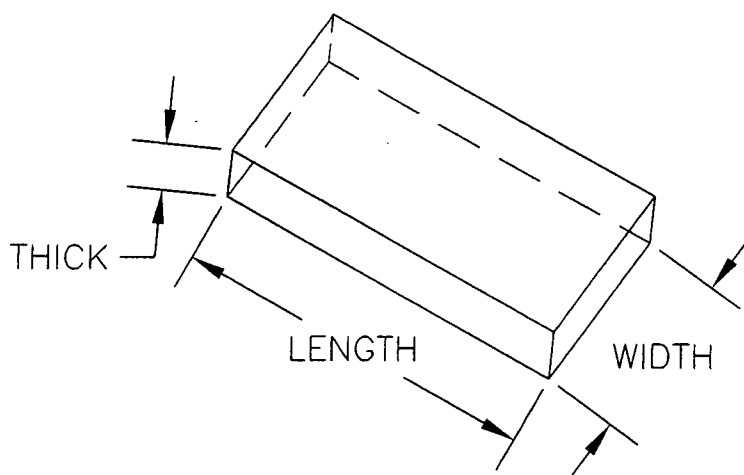
QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH, WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

WORK ORDER
NO. 22241

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 17, 2005
01:31 pm

Work Order No	: 0022241	Department Code:	
Project Name	: D6101-003	Burden Flags	: NNNNNNNN
Project For	: WK510	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D6101-003	Invoice Number	:
Description	: 7075-T7351 2X6.25X7.875	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 50	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 01-17-05		
Est Finish Date	: 02-28-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
=====					
Burden	0.00	0.00	0.00		
=====					
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

298337
Ship Date

2004-11-22

P.O. No./Govt Contract No.

CB3049

325003
B.L. No.

64469

Invoice No.

72424

Customer

C&B-WALLINGFORD

Alcoa No. Item

DS-83103-1

Page 1

Ship To: COPPER & BRASS SALES INC
WALLINGFORD BRANCH
5 STERLING DRIVE
WALLINGFORD, CT 06492

Item Description

2.0000 IN TK X 48.500 IN W X 144.500 IN LN CAT D 164164 (N) A/T 7075-
T7351 RECTANGLE MILL FINISH, USI 3MM DEAD ZONE REQ'D BOTH SIDES,
SAWED ({ P/N 091548-8 }). PER AMS-QQ-A-250/12
& EXCEPT MARKING MMS159 REV N &
EXCEPT MARKING AMS4078 REV F & EXCEPT MARKING
ASTMB209 REV 04 & EXCEPT MARKING BSS7055 REV A & MIL-STD-
2154 & EXCEPT MARKING ASTMB594 REV 02 &
EXCEPT MARKING PS21211 REV J ((MARKED))
INTERLEAVED SKID WGT: 4000 LB QUAN TOL
+/-10 % USI CL A 3 MM CQR D164164 REV 12 CUST REQ 04-11-
19 *** W/E 04-11-27 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	232467	662441	2855	2	PC	-
2	232468	662441	1418	1	PC	-
			4273	3		

Notes for CQR: D164164.12
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PRODUCT
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12.
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.

CQR: D164164.12 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
		KSI	KSI	PCT
T7351	Long Transv.	Max	68.9	
		Min	69.0	6
T7351	Elec. Cond. (EC)	% MIN	38.0	PCT

T7351 Elec. Cond. (EC) % MIN 38.0 FCI										Other	Other	
Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Each	Total	Aluminum
	Max	.40	.50	2.0	.30	2.9	.28	6.1	.20	.05	.15	
Alloy 7075	Min			1.2		2.1	.18	5.1				REMAIN

PECHINEY ROLLED PRODUCTS

COPPER & BRASS SALES, INC.
5 STERLING DRIVE
WALLINGFORD CT

06492

SOLD TO

COPPER AND BRASS SALES
P.O. BOX 5116
SOUTHFIELD MI

48086

CERTIFIED TEST REPORT

RAVENSWOOD, WV 26164

COPPER&BR		J97104 1512		INCLUSION		SERIAL#: 20041219J97104		1	
ORDER PURCHASE ORDER NO. & ITEM				PECHINEY ORDER NO.					
19595				235-303317					
CLAD.	TEMPER	GAUGE	WIDTH	LENGTH					
00	T7351	2.00000	48.500	128.000					
OLD PLATE-DIST GE PEC PLATE, SAWED MILL MER SPECIFICATION									
MS-QQ-A-250/12				B/L NUMBER		DATE SHIPPED			
J1548-8				J97100		12/19/04			
T SHIPPED		NO. OF PIECES		GOVT. CONTRACT NO.					
12,700		10							

CERTIFICATION
"Pechiney Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Pechiney Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."

PECHINEY ROLLED PRODUCTS

P.O. BOX 68

RAVENSWOOD, WV 26164

JODY S. THYER LABORATORY SPECIALIST

LOT NUMBER		TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % IACS								
				MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.							
01301		LT	2	73.8	74.4	63.3	64.4	12.0	12.5	40.3	40.4							
01311		LT	2	***** T7351 73.5	73.9	63.0	63.5	***** 12.5	12.5	40.5	41.3							
ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS																		
MIL-STD-2154 100% SONIC TESTED MINUS DEAD ZONE CLASS A																		
ALSO CONFORMS TO BSS 7055 CL A SONIC																		
ALSO CONFORMS TO MMS 159J. ASTM B209-02, AMS 4078E																		
ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
SEE ACTUAL CHEMICAL COMPOSITION																		
ALUMINUM REMAINDER																		

PECHINEY ROLLED PRODUCTS

COPPER & BRASS SALES, INC.
5 STERLING DRIVE
WALLINGFORD CT

06492

SOLD TO

COPPER AND BRASS SALES
P.O. BOX 5116
SOUTHFIELD MI

48086

CERTIFIED TEST REPORT

RAVENSWOOD, WV 26164

COPPER&BR J97104 1512

INCLUSION

SERIAL#: 20041219J97104 2

ORDER PURCHASE ORDER NO. & ITEM

39595

PECHINEY ORDER NO.

235-303317

	CLAD.	TEMPER	GAUGE	WIDTH	LENGTH
075	00	T7351	2.00000	48.500	128.000

ORDERED

OLD PLATE-DIST GE

PEC PLATE, SAWED MILL

ORDER SPECIFICATION

MS-QQ-A-250/12

NUMBER

91548-8

B/L NUMBER

J97100

DATE SHIPPED

12/19/04

QUANTITY SHIPPED

NO. OF PIECES

GOVT CONTRACT NO.

12,700

10

CERTIFICATION

"Pechiney Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Pechiney Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."

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JODY S. THYEN LABORATORY SPECIALIST

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % IACS									
			MIN	MAX.	MIN	MAX.	MIN.	MAX	MIN	MAX								
ACTUAL CHEMICAL COMPOSITION																		
01301	SI=0.07	FE=0.11	CU= 1.5	MN=0.01	MG= 2.6	CR=0.19	ZN= 5.6	TI=0.02										
	OTHERS-EACH: .05		MAX.		OTHERS TOTAL: .15		MAX.		AL REMAINDER									
01311	SI=0.07	FE=0.11	CU= 1.5	MN=0.01	MG= 2.6	CR=0.19	ZN= 5.6	TI=0.02										
	OTHERS-EACH: .05		MAX.		OTHERS TOTAL: .15		MAX.		AL REMAINDER									
THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE.																		
THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW.																		
CHEMISTRY BY OES: ARKSPARK																		
CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT.																		
WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399.																		
WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557.																		
"END OF CERTIFICATION"																		
ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
	MIN	MAX	MIN.	MAX	MIN.	MAX.	MIN	MAX.	MIN	MAX	MIN	MAX	MIN.	MAX.	MIN	MAX	EACH MAX.	TOTAL MAX.
SEE ACTUAL CHEMICAL COMPOSITION																		
ALUMINUM REMAINDER																		